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(54) Title: OPTICAL FIBRE SUBMARINE REPEATER CABLE WITH COMBINED INSULATION/JACKET

(57) **Abstract:** An optical fibre submarine repeater cable with combined insulation/jacket is disclosed. The optical fibre submarine repeater cable with combined insulation/jacket is characterised in that the combined insulation/jacket comprises at least two layers of which one layer is an insulating layer, and of which an inner layer, that is situated on the inside of the insulating layer, has a resistivity that is lower than that of the insulating layer, so that the ratio of the resistivity of the inner layer to the resistivity of the insulating layer is less than 0.3:1. Preferably, the inner layer comprises the same base polymer as the insulating layer. It is preferred that the insulating layer comprises a multi-modal polyolefin that has been obtained by polymerisation of at least one olefin in at least two stages and has a density of 0.955 g/cm³ and a melt flow rate (MFR₂) of 0.2-3.0 g/10 min, and that the multimodal polyolefin comprises at least a first and a second polyolefin fraction, of which the first fraction has either (a) a density of 0.930-0.975 g/cm³ and a melt flow rate (MFR₂) of 50-2000 g/10 min, or (b) a density of 0.88-0.93 g/cm³ and a melt flow rate (MFR₂) of 0.01-0.8 g/10 min.

OPTICAL FIBRE SUBMARINE REPEATER CABLE WITH COMBINED
INSULATION/JACKET

Field of the invention

The present invention relates to an optical fibre submarine repeater cable with combined insulation/jacket.

Technical background

5 Submarine communication cables have been used for more than 150 years. Previously such cables have transmitted the information as electric signals, but more recently optical fibre cables which transmit the information as optical signals have come into increasing
10 demand.

Generally, an optical fibre submarine cable comprise a bundle of optical fibres, usually up to about 15-20 fibres, protected by a surrounding insulation and an external jacket. To provide sufficient mechanical
15 strength to the cable it is usually armoured, i.e. it includes metallic wires, preferably steel wires incorporated in the construction such that these may surround the bundle of optical fibres.

In an optical fibre submarine cable that covers
20 large distances such as between two continents, the optical signal is gradually attenuated with increasing distance. To overcome this the signal is amplified at certain intervals such as each 10 to 12 kilometers. The amplification of the signal is done by underwater
25 amplifiers called repeaters. One repeater is provided in association with the optical fibre cable every 10 to 12 kilometer. Such cables are called optical fibre submarine repeater cables. The repeaters are powered by direct current (DC), typically with a maximum voltage of about
30 10 kV, from the ends of the system. To feed the repeaters with DC a separate DC cable is needed.

However, instead of providing a separate DC cable in addition to the submarine optical fibre cable, the DC cable is integrated with the optical fibre cable by

providing the optical fibre cable with a central high voltage conductor in the form of a conducting metal tube, preferably of copper, that surrounds and protects the optical fibre bundle. The previously mentioned wire 5 armour is arranged on the outside of the copper tube and the whole aggregate is surrounded by an insulating layer and an external jacket that may be combined into one single combined insulation/jacket layer.

In addition to being able to transmit optical 10 signals over large distances an optical fibre submarine repeater cable must possess several other critical characteristics to cope with the rigours of manufacture, installation and operation of the cable.

Thus, during the laying of a submarine cable from a 15 vessel it is subjected to severe mechanical stress. More particularly, a cable that is coiled horizontally on board the vessel is twisted when it is pulled by a caterpillar and metered out into the sea. The cable then sinks by gravity to the bottom of the sea. In order to 20 stay securely on the bottom of the sea the buoyancy of the cable should be as low as possible. Further, the cable must have a good resistance to abrasion such as against rocks and movement due to sand erosion. The cable should, of course, also be resistant to corrosion by salt 25 water.

These are very demanding requirements. To fulfil them the insulation/jacket composition should possess a combination of important properties. Thus, for ease of manufacture it should have a good processability, i.e. be 30 easy to extrude. To withstand stress and environmental influence during use of the cable the composition should have a high Environmental Stress Cracking Resistance (ESCR); to prevent corrosion by salt water of the metal parts of the cable the composition should have good 35 barrier properties; to withstand the wear and tear during the laying and use of the cable the composition should have a high abrasion resistance. Further, to impart good

electrical characteristics to the cable the composition should have a high cleanliness, i.e. a low content of extraneous material such as particles. Further, the cable should be designed for a service life of more than 5 20 years. This poses a technological challenge in that a single rupture of the combined insulation/jacket causes malfunction of the whole length. Consequently, the damaged area must be recovered from the seabed and repair effected on the high seas before the system can be 10 returned to service.

The dimensions of the combined insulation and jacket are determined by the level of mechanical protection required, the voltage employed and the handling characteristics of the completed cable, including the characteristics for storage and laying. Generally, the combined insulation/jacket has a thickness of about 3-7 mm, 15 usually about 5 mm and is made of an unimodal polyethylene, more particularly high density polyethylene (HDPE).

20 There is a need to increase the maximum possible length of an optical fibre submarine repeater cable. Such increase in length increases the transmission voltage loss incurred through the small, but finite, resistance of the central copper conductor. To compensate and 25 achieve the minimum voltage needed at the most remote repeater the input voltage level needs to be increased.

However, with present technology, it is generally not feasible to increase the voltage level further at an unchanged thickness of the combined insulation/jacket, 30 because this would increase the electric field strength beyond that which the combined insulation/jacket can withstand without breakdown. In particular, a limiting factor in this connection is the enhanced electrical field adjacent to the central metallic components of the 35 cable. The geometry of the individual wires that may be used as armour around the central conductor tube of the cable or the central conductor tube enclosing the armour

wires causes an enhanced electric field. More particularly, the high curvature (small radius of curvature) of these wires or tube entails an increased electric field and thus an increased electrical stress in 5 this area.

Therefore, if the voltage level is to be increased a commensurate increase in insulation thickness is required. As an example a twofold increase in length might necessitate a twofold increase in voltage leading 10 to a twofold increase in insulating thickness if existing design stresses are used. The resulting increase in volume of cable leads to a reduction in the length that it is possible to store within the cable-laying vessel. The handling of the cable will be further complicated by 15 the resultant increase in minimum bending radii (of the order of 10-20 times the cable diameter) and the increased buoyancy in seawater (the insulation/jacket comprises a polymer of a density of less than 1 g/cm³ and the greater the proportion of insulation/jacket the 20 greater the buoyancy of the cable will be).

It would be an important technical progress if an optical fibre submarine repeater cable with a combined insulation/jacket could be provided which allowed an increased voltage and thus an increased maximum or total 25 cable length, at a substantially unchanged thickness of the combined insulation/jacket.

Summary of the invention

It is an object of the present invention to eliminate or alleviate the above-mentioned problem and 30 provide an optical fibre submarine repeater cable that has excellent characteristics and allows an increase in the maximum cable length, i.e. the total length of the repeater chain.

It has been found that the above object may be 35 achieved by adding, at least on the inside of the insulating layer of the combined insulation/jacket a layer with a lower resistivity than the insulating layer.

This inner layer has such a resistivity so that the ratio of the resistivity of the inner layer to the resistivity of the insulating layer is less than 0.3:1. Preferably the resistivity is lowered by the incorporation of carbon 5 black into the inner layer. In addition to the inner, lower resistivity layer the combined insulation/jacket may also be provided with an outer, lower resistivity layer.

The present invention thus provides an optical fibre 10 submarine repeater cable with combined insulation/jacket, characterised in that the combined insulation/jacket comprises at least two layers of which one layer is an insulating layer, and of which an inner layer, that is situated on the inside of the insulating layer, has a 15 resistivity that is lower than that of the insulating layer, so that the ratio of the resistivity of the inner layer to the resistivity of the insulating layer is less than 0.3:1.

Further distinctive features and advantages of the 20 present invention will appear from the following description and the appended claims.

Detailed description of the invention

In order to facilitate the understanding of the present invention a detailed description will be given 25 below.

According to a general aspect of the present invention the combined insulation/jacket may comprise a conventional insulating material as used in present combined insulation/jackets. By the addition of the 30 inner, lower resistivity layer the overall breakdown strength of the combined insulation/jacket will be increased so that it can withstand an increased operative electrical stress.

By the addition of the inner, lower resistivity 35 layer the peak electrical stress is moved away from the armour wires or central conductor tube of the cable, i.e. where different materials are in contact with each other,

and into the insulation layer. The area where the different materials (polymer/metal) are in contact with each other is a sensitive area. More particularly, the bonding between the different materials is affected by 5 the electrical and mechanical stress to which the cable is subjected. Displacing the peak electrical stress from this area and into the insulation layer therefore results in an increased the life expectancy of the cable.

According to a preferred aspect of the present invention 10 the insulating layer of the combined insulation/-jacket comprises an insulating polymer material with high cleanliness.

More preferably, the insulating layer of the combined insulation/jacket comprises a multimodal poly-15 olefin with high cleanliness.

Still more preferred, the insulating layer of the combined insulation/jacket comprises a multimodal polyolefin with a density of 0.910-0.960 g/cm³ and an MFR₂ of 0.2-6.0 g/10 min and is free from particles with a 20 dimension larger than 0.5 mm in a 1 kg sample of material.

Most preferably, the insulating layer of the combined insulation/jacket is a multimodal polyolefin that has been obtained by polymerisation of at least one 25 olefin in at least two stages and has a density of 0.915-0.955 g/cm³ and a melt flow rate (MFR₂) of 0.2-3.0 g/10 min, and the multimodal polyolefin comprises at least a first and a second polyolefin fraction, of which the first fraction has either (a) a density of 30 0.930-0.975 g/cm³ and a melt flow rate (MFR₂) of 50-2000 g/10 min, or (b) a density of 0.88-0.93 g/cm³ and a melt flow rate (MFR₂) of 0.01-0.8 g/10 min.

It is particularly preferred that the inner, lower resistivity layer is comprised of the same base polymer 35 as the insulating layer of the combined insulation/jacket.

The inner, lower resistivity layer differs from the insulating layer in having a resistivity lowering material incorporated into the base polymer. Such resistivity lowering material may consist of electrically 5 conductive particles, e.g. metal particles. It is highly preferred that the resistivity lowering material incorporated into the inner, lower resistivity layer consists of carbon black. The amount of resistivity lowering material such as carbon black, incorporated into 10 the inner layer should be sufficient to lower the resistivity of the inner layer such that the electrical stress adjacent to the metallic components (such as wires that may be used for armour or encapsulating tubes) is reduced. The level of the reduction results in an 15 electrical stress, adjacent to the metallic components, of preferably less than 1.6 kV/mm and more preferably less than 1 kV/mm. The reduction is achieved by a controlled reduction of the resistance of the polymer layer adjacent to the metallic components. The resistance 20 of the layer is determined by careful selection of the thickness of the layer and the resistivity of the layer.

As mentioned above, the ratio of the resistivity of the inner layer to the resistivity of the insulating layer is less than 0.3:1. Preferably, the resistivity 25 ratio is less than 0.15:1, and more preferably less than 0.065:1. In addition the resistivity of both the inner layer and of the insulating layer should be more than $10^{16} \Omega \text{ cm}$. To achieve this the amount of resistivity lowering material such as carbon black preferably is 30 0.5-20 % by weight, more preferably 0.5-10 % by weight, and most preferably 1-5 % by weight, based on the total weight of the inner layer.

The present invention will now be described with reference to a preferred embodiment where the insulating 35 layer of the combined insulation/jacket comprises a multimodal polyolefin with high cleanliness and the

inner, lower resistivity layer is comprised of the same base polymer as the insulating layer.

First, though, some terms and expressions used in the specification and claims will be defined.

5 By the "modality" of a polymer is meant the structure of the molecular-weight distribution of the polymer, i.e. the appearance of the curve indicating the number of molecules as a function of the molecular weight. If the curve exhibits one maximum, the polymer is referred to as
10 "unimodal", whereas if the curve exhibits a very broad maximum or two or more maxima and the polymer consists of two or more fractions, the polymer is referred to as "bimodal", "multimodal" etc. In the following, all polymers whose molecular-weight-distribution curve is very
15 broad or has more than one maximum are jointly referred to as "multimodal".

The processability is defined herein in terms of the extruder output in kg/h at a given pressure in MPa. The extruder used is a single screw one of type Nokia-Maillefer with an L/D ratio of 24/1 and diameter 60 mm,
20 run at 180°C. It is an advantage if the output is as high as possible at a given extruder pressure.

The Environmental Stress Cracking Resistance (ESCR), i.e. the resistance of the polymer to the formation of
25 cracks under the action of mechanical stress and a reagent in the form of a surfactant, is determined in accordance with ASTM D 1693 A, the reagent employed being 10% Igepal CO-630. The results are indicated as the percentage of cracked sample rods after a given time in
30 hours. F20 means e.g. that 20% of the sample rods were cracked after the time indicated.

The "melt flow rate" (MFR) is determined in accordance with ISO 1133 and is equivalent to the term "melt index" previously used. The melt flow rate, which is
35 indicated in g/10 min, is an indication of the flowability, and hence the processability, of the polymer. The higher the melt flow rate, the lower the viscosity of

the polymer. The melt flow rate is determined at 190°C and at a loading of 2,1 kg (MFR₂; ISO 1133, condition D).

The barrier properties are determined in terms of the water vapour transmission rate according to

5 ASTM F 1249.

The abrasion resistance is determined as Shore D hardness according to DIN 53505 (3 sec).

As a measure of the strength of the polymer its yield strength as well as its elongation at yield at an 10 extension of 50 mm/min is determined according to ISO 527.

As indicated in the foregoing, the preferred insulating layer of the combined insulation/jacket comprises a multimodal polyolefin. By "polyolefin" is 15 meant an olefin homopolymer or copolymer. The olefin monomer is preferably selected from ethylene or propylene. The comonomer is preferably selected from α-olefins having 3-12 carbon atoms, more preferably 1-butene, 1-hexene, 4-methyl-1-pentene, and 1-octene, 20 when the olefin monomer is ethylene. When the olefin monomer is propylene the comonomer is preferably selected from ethylene and α-olefins having 4-12 carbon atoms, more preferably ethylene, 1-butene, 1-hexene, 4-methyl-1-pentene, and 1-octene.

25 By "polyethylene" or "ethylene (co)polymer" is meant an ethylene homopolymer or copolymer. Similarly, by "polypropylene" or "propylene (co)polymer" is meant a propylene homopolymer or copolymer.

It is previously known to produce multimodal, in 30 particular bimodal, polyolefins, preferably multimodal polyethylene, in two or more reactors connected in series. As instances of this prior art, mention may be made of EP 040 992, EP 041 796, EP 022 376 and WO 92/12182, which are hereby incorporated by way of 35 reference as regards the production of multimodal polymers. According to these references, each and every one

of the polymerisation stages can be carried out in liquid phase, slurry or gas phase.

According to the present invention, the main polymerisation stages are preferably carried out as a combination of slurry polymerisation/gas-phase polymerisation or gas-phase polymerisation/gas-phase polymerisation. The slurry polymerisation is preferably performed in a so-called loop reactor. The use of slurry polymerisation in a stirred-tank reactor is not preferred in the present invention, since such a method is not sufficiently flexible for the production of the inventive composition and involves solubility problems. In order to produce the inventive composition of improved properties, a flexible method is required. For this reason, it is preferred that the composition is produced in at least two main polymerisation stages in a combination of loop reactor/gas-phase reactor or gas-phase reactor/gas-phase reactor. It is especially preferred that the composition is produced in two main polymerisation stages, in which case the first stage is performed as slurry polymerisation in a loop reactor and the second stage is performed as gas-phase polymerisation in a gas-phase reactor. Optionally, the main polymerisation stages may be preceded by a prepolymerisation, in which case up to 20% by weight, preferably 1-10% by weight, of the total amount of polymers is produced. Generally, this technique results in a multimodal polymer mixture through polymerisation with the aid of a Single Site or Ziegler-Natta catalyst in several successive polymerisation reactors. In the production of, say, a bimodal polyethylene, which according to the invention is the preferred polymer, a first polyethylene fraction is produced in a first reactor under certain conditions with respect to monomer composition, hydrogen-gas pressure, temperature, pressure, and so forth. After the polymerisation in the first reactor, the reaction mixture including the polymer produced is fed to a second reactor, where further

polymerisation takes place under other conditions. Usually, a first polymer fraction of high melt flow rate (low molecular weight) and with a moderate or small addition of comonomer, or no such addition at all, is 5 produced in the first reactor, whereas a second polymer fraction of low melt flow rate (high molecular weight) and with a greater addition of comonomer is produced in the second reactor. As comonomer, use is commonly made of other olefins having up to 12 carbon atoms, such as α - 10 olefins having 3-12 carbon atoms, e.g. propene, butene, 4-methyl-1-pentene, hexene, octene, decene, etc., in the copolymerisation of ethylene. The resulting end product consists of an intimate mixture of the polymer fractions from the two reactors, the different molecular-weight- 15 distribution curves of these polymer fractions together forming a molecular-weight-distribution curve having a broad maximum or two maxima, i.e. the end product is a bimodal polymer mixture. Since multimodal, and especially bimodal, polymers, preferably ethylene polymers, and the 20 production thereof belong to the prior art, no detailed description is called for here, but reference is had to the above specifications.

It should be pointed out that, in the production of two or more polymer fractions in a corresponding number 25 of reactors connected in series, it is only in the case of the fraction produced in the first reactor stage and in the case of the end product that the melt flow rate, the density and the other properties can be measured directly on the material removed. The corresponding 30 properties of the polymer fractions produced in reactor stages following the first stage can only be indirectly determined on the basis of the corresponding values of the materials introduced into and discharged from the respective reactor stages.

35 Even though multimodal polymers and their production are known per se, it is not, however, previously known to use such multimodal polymers as the composition of a

combined insulation/jacket of an optical fibre submarine repeater cable. Above all, it is not previously known to use in this context multimodal polyolefins having the specific values of density, melt flow rate and cleanliness as are required in the present invention.

As hinted at above, it is preferred that the multimodal polyolefin in the combined insulation/jacket according to the invention is a bimodal polyolefin. It is also preferred that this bimodal polyolefin has been produced by polymerisation as above under different polymerisation conditions in two or more polymerisation reactors connected in series. Owing to the flexibility with respect to reaction conditions thus obtained, it is most preferred that the polymerisation is carried out in a loop reactor/a gas-phase reactor, a gas-phase reactor/a gas-phase reactor or a loop reactor/a loop reactor as the polymerisation of one, two or more olefin monomers, the different polymerisation stages having varying comonomer contents. Preferably, the polymerisation conditions in the preferred two-stage method are so chosen that a comparatively low-molecular polymer fraction having a moderate, low or, which is preferred, no content of comonomer is produced in one stage, preferably the first stage, owing to a high content of chain-transfer agent (hydrogen gas), whereas a high-molecular polymer fraction having a higher content of comonomer is produced in another stage, preferably the second stage. The order of these stages may, however, be reversed.

Preferably, the multimodal polyolefin in accordance with the invention is a multimodal polypropylene or, which is most preferred, a multimodal polyethylene.

In view of the above, a preferred multimodal polyethylene according to the invention consists of a low-molecular ethylene homopolymer mixed with a high-molecular copolymer of ethylene and butene, 4-methyl-1-pentene, 1-hexene or 1-octene.

It is particularly preferred that the properties of the individual polymers in the multimodal polyolefin according to the invention should be so chosen that the final multimodal polyolefin has a density of about 5 0.915-0.955 g/cm³, preferably about 0.920-0.950 g/cm³, and a melt flow rate of about 0.2-3.0 g/10 min, preferably about 0.2-2.0 g/10 min. According to the invention, this is preferably achieved by the multimodal polyolefin comprising a first polyolefin fraction having 10 a density of about 0.930-0.975 g/cm³, preferably about 0.955-0.975 g/cm³, and a melt flow rate of about 50-2000 g/10 min, preferably about 100-1000 g/ 10 min, and most preferred about 200-600 g/10 min, and at least a second polyolefin fraction having such a density and such 15 a melt flow rate that the multimodal polyolefin obtains the density and the melt flow rate indicated above.

If the multimodal polyolefin is bimodal, i.e. is a mixture of two polyolefin fractions (a first olefin polymer and a second olefin polymer), the first polyolefin fraction being produced in the first reactor and having the density and the melt flow rate indicated above, the density and the melt flow rate of the second polyolefin fraction, which is produced in the second reactor stage, may, as indicated in the foregoing, be 20 indirectly determined on the basis of the values of the 25 materials supplied to and discharged from the second reactor stage.

In the event that the multimodal polyolefin and the first polyolefin fraction have the above values of 30 density and melt flow rate, a calculation indicates that the second polyolefin fraction produced in the second stage should have a density in the order of about 0.88-0.93 g/cm³, preferably 0.91-0.93 g/cm³, and a melt flow rate in the order of about 0.01-0.8 g/10 min, 35 preferably about 0.05-0.3 g/ 10 min.

As indicated in the foregoing, the order of the stages may be reversed, which would mean that, if the

final multimodal polyolefin has a density of about 0.915-0.955 g/cm³, preferably about 0.920-0.950 g/cm³, and a melt flow rate of about 0.2-3.0 g/10 min, preferably about 0.2-2.0 g/10 min, and the first polyolefin 5 fraction produced in the first stage has a density of about 0.88-0.93 g/cm³, preferably about 0.91-0.93 g/cm³, and a melt flow rate of 0.01-0.8 g/10 min, preferably about 0.05-0.3 g/10 min, then the second polyolefin fraction produced in the second stage of a two-stage 10 method should, according to calculations as above, have a density in the order of about 0.93-0.975 g/cm³, preferably about 0.955-0.975 g/cm³, and a melt flow rate of 50-2000 g/ 10 min, preferably about 100-1000 g/10 min, and most preferred about 200-600 g/10 min. This order of 15 the stages in the production of the olefin polymer mixture according to the invention is, however, less preferred.

In order to optimise the properties of the combined insulation/jacket according to the invention, the 20 individual polymer fractions in the multimodal polyolefin should be present in such a weight ratio that the aimed-at properties contributed by the individual polymer fractions are also achieved in the final olefin multimodal polyofin. As a result, the individual polymer 25 fractions should not be present in such small amounts, such as about 10% by weight or below, that they do not affect the properties of the multimodal polyolefin. To be more specific, it is preferred that the amount of polyolefin fraction having a high melt flow rate (low-molecular weight) makes up at least 25% by weight but no more 30 than 75% by weight of the multimodal polyolefin, preferably 35-55% by weight of the multimodal polyolefin, thereby to optimise the properties of the end product.

As mentioned earlier, it is preferred that the 35 insulating layer of the combined insulation/jacket of the present invention is comprised of an insulating polymer material with high cleanliness, preferably an insulating,

multimodal polyolefin with high cleanliness. A high cleanliness contributes to good electric properties of the combined insulation/jacket such that it can withstand a high operating stress in terms of electric field before 5 electrical breakdown occurs. While the current combined insulation/jacket materials of optical fibre submarine repeater cables typically withstand a maximum electrical field level of about 2 kV/mm, it is contemplated that this level could be increased to about 10 kV/mm with the 10 combined insulation/jacket having an insulating layer with high cleanliness as defined above. With the further addition of an inner, lower resistivity layer to the combined insulation/jacket it is contemplated that the maximum electric field level could be increased another 15 5 kV/mm, i.e. to about 15 kV/mm in total. This means that with a thickness of the combined insulation/jacket of about 5 mm the voltage could be increased to about 75 kV and thus the total cable length might be increased more than 7 times. This constitutes a significant technical 20 progress in the field of optical fibre submarine repeater cables.

As stated earlier, the insulating layer of the combined insulation/jacket is preferably comprised of the above defined multimodal polyolefin. In this connection 25 "is comprised of" means that the layer is substantially made up of the multimodal polyolefin. Preferably, the layer consists of the multimodal polyolefin. In any case the cleanliness of the multimodal polyolefin is decisive for the cleanliness of the combined insulation/jacket.

30 The cleanliness of the multimodal polyolefin material is defined in terms of lack of contaminants in the material. A contaminant is a particle with any dimension larger than 70 μm not inherent in the product formulation. Also oxidised polyolefin particles larger 35 than 100 μm are considered contaminants if they show a sharp edge to the surroundings. As mentioned earlier, the multimodal polyolefin should be free of particles larger

than 0.5 mm in a 1 kg sample of material. Preferably, a 1 kg sample of the multimodal polyolefin is free from particles with any dimension larger than 0.2 mm, more preferably 0.1 μm , in which case the multimodal polyolefin is referred to as superclean.

The determination of the cleanliness of the multimodal polyolefin can be made by extruding a 0.5 mm thick tape of the multimodal polyolefin and examining the tape with an automatic contamination detector based on a light source and a sensitive detector. When a contaminant is recorded the tape is automatically marked in the vicinity of the contaminant. After the extrusion is completed the tape is manually inspected for contamination indications and each contaminant is individually characterised and measured. The longest dimension of each contaminant is measured by using a measuring-microscope at approximately 100x magnification. Each inspected tape volume should have a weight of 1 kg.

When testing a preferred multimodal polyethylene for the insulating layer of a combined insulation/jacket of the present invention having an MFR₂ of 1.7 g/10 min and a density of 0.942 g/cm³ the tapes showed the following cleanliness:

Tape 1: 0 particles with a dimension larger than 0.5 mm, 0 particles with a dimension of 0.2-0.5 mm, and 1 particle with a dimension of 0.1-0.2 mm;

Tape 2: 0 particles with a dimension larger than 0.5 mm, 0 particles with a dimension of 0.2-0.5 mm, and 2 particles with a dimension of 0.1-0.2 mm.

According to a particularly preferred aspect of the required cleanliness of the multimodal polyolefin may be secured and/or increased by filtering the multimodal polyolefin after the production thereof. This is achieved by passing the multimodal polyolefin through a filter with 40-250 μm , preferably 40-100 μm filter openings. The filtering is preferably carried out by extruding the multimodal polyolefin through an extruder with an

appropriate filter attached to the die. The filter may be of a fixed type, i.e. permanently secured to the extruder die, or of a changing type, i.e. two alternating filters, a filter that moves continuously past the die, or any 5 type of commercial filter.

It is understood that the filtering of the multimodal polyolefin is facilitated by the good processability thereof. While a conventional unimodal polyethylene for a combined insulation/jacket has a processability, as defined above, of about 20 kg/h at an 10 extruder pressure of about 25 MPa, a preferred multimodal polyethylene for a combined insulation/jacket of the present invention having an MFR₂ of 1.7 g/10 min and a density of 0.942 g/cm³ has an output of about 60 kg/h at 15 an extruder pressure of about 25 MPa. With a view to achieve good processability it is preferred that the multimodal polyolefin has an MFR₂ of at least 1.5 g/10 min. This also facilitates the filtering of the multimodal polyolefin described above.

Contributing to the cleanliness of the multimodal polyolefin of the insulating layer of the combined insulation/jacket is the fact that, except for conventional stabilisers such as antioxidants and light 20 stabilisers, it does not contain any additives. The stabilisers in the multimodal polyolefin of the invention are added in conventional amounts of at most about 1 % by weight, preferably at most about 0.5 % by weight, and most preferred about 0.1 % by weight of the multimodal polyolefin.

Another important aspect of the multimodal polyolefin is that it should have a good Environmental Stress Cracking Resistance (ESCR) as defined above. Thus, 30 the multimodal polyolefin preferably has the following ESCR properties: F10 > 1500 h, more preferably > 8000 h; F1 > 700 h, more preferably > 3000 h.

As indicated previously, the composition of the present invention should have good barrier properties in

order to prevent corrosion by salt water of the metal parts of the cable. More particularly, it is preferred that the composition has a water vapour transmission rate of less than $4.5 \text{ g/m}^2/24 \text{ h}$, determined according to 5 ASTM F 1249.

Also, a good abrasion resistance is important to the cable according to the invention. It is preferred that the composition of the cable of the present invention has an abrasion resistance, determined according to DIN 53505 10 as Shore D hardness (3 sec) of over 55. Moreover, the ratio of the Shore D hardness at 1 sec to the Shore D hardness at 3 sec, i.e.

15
$$\frac{\text{Shore D (1 sec)}}{\text{Shore D (3 sec)}}$$

should preferably be more than 1.05.

A further important property of the composition of the cable of the present invention is its strength, 20 determined as yield strength and elongation at yield at 50 mm/min. Preferably, the yield strength is over 18 MPa and the elongation at yield is over 10%.

As mentioned earlier the inner lower resistivity layer is preferably comprised of the same base polymer as 25 the insulating layer of the combined insulation/jacket of the present invention. Preferably therefore, the inner lower resistivity layer comprises the above defined multimodal polyolefin as the base polymer. The fact that the insulating layer and the inner lower resistivity 30 layer comprise the same base polymer facilitates and reduces the cost of manufacture of the combined insulation/jacket. More importantly, however, it secures a good compatibility between the layers. The inner lower resistivity layer differs from the insulating layer in 35 having a resistivity such that the resistivity ratio between the layers is less than 0.3:1. As mentioned earlier, this is preferably achieved by adding carbon black to the polyolefin of the inner, lower resistivity

layer. Preferably the amount of carbon black added is 0.5-20 % by weight, more preferably 0.5-10 % by weight, and most preferably 1-5 % by weight, based on the total weight of the inner layer.

5 In order to further illustrate the present invention the following table 1 is given, wherein preferred upper limits are listed for the resistivity ratio between the lower resistivity inner layer and the insulating layer at different thicknesses of the layers and voltages of the
10 cable.

Table 1

Cable voltage (kV)	Thickness of inner layer (A) (mm)	Thickness of insulating layer (B) (mm)	Upper limit of resistivity ratio of A:B
10	0.05	5	0.15
10	0.1	5	0.15
10	0.5	5	0.15
10	0.05	7	0.17
10	0.1	7	0.17
10	0.5	7	0.17
10	0.05	10	0.19
10	0.1	10	0.19
10	0.5	10	0.19
30	0.05	5	0.05
30	0.1	5	0.05
30	0.5	5	0.05
30	0.05	7	0.055
30	0.1	7	0.055
30	0.5	7	0.055
30	0.05	10	0.065
30	0.1	10	0.065
30	0.5	10	0.065
50	0.05	5	0.03
50	0.1	5	0.03
50	0.5	5	0.03
50	0.05	7	0.035
50	0.1	7	0.035
50	0.5	7	0.035
50	0.05	10	0.04
50	0.1	10	0.04
50	0.5	10	0.04

Although the present invention has been described with reference to a preferred embodiment with a combined insulation/jacket consisting of an insulating layer and an inner, lower resistivity layer, it should be under-

stood that the present invention is not limited thereto, but can be varied within the scope of the appended claims. As an example, in certain applications it may e.g. be desirable to add an outer, lower resistivity 5 layer. Preferably, this outer, lower resistivity layer has the same composition as the inner, lower resistivity layer. Such an additional outer, lower resistivity layer may be the desirable where intimate contact with material which provides the external ground electrode, cannot be 10 guaranteed or where abrasion of the outer surface may produce cavities, which when filled with water, may act as points which increase the local electrical stress, thereby precipitating failure.

CLAIMS

1. An optical fibre submarine repeater cable with combined insulation/jacket, characterised in 5 that the combined insulation/jacket comprises at least two layers

of which one layer is an insulating layer, that comprises a multimodal polyolefin with a density of 0.910-0.960 g/cm³ and an MFR₂ of 0.2-6.0 g/10 min and is 10 free from particles with a dimension larger than 0.5 mm in a 1 kg sample of material; and

of which an inner layer, that is situated on the inside of the insulating layer, has a resistivity that is lower than that of the insulating layer, so that the 15 ratio of the resistivity of the inner layer to the resistivity of the insulating layer is less than 0.3:1.

2. A cable as claimed in claim 1, wherein the multimodal polyolefin has been filtered through a filter with 40-250 µm filter openings.

20 3. A cable as claimed in claim 1 or 2, wherein the multimodal polyolefin is selected from ethylene and propylene (co)polymers.

4. A cable as claimed in any one of claims 1-3, wherein the multimodal polyolefin is bimodal.

25 5. A cable as claimed in any one of claims 1-4, wherein the multimodal polyolefin has been obtained by polymerisation of at least one olefin in at least two stages and has a density of 0.915-0.955 g/cm³ and a melt flow rate (MFR₂) of 0.2-3.0 g/10 min, and that the multimodal polyolefin comprises at least a first and a second polyolefin fraction, of which the first fraction has either (a) a density of 0.930-0.975 g/cm³ and a melt flow rate (MFR₂) of 50-2000 g/10 min, or (b) a density of 0.88-0.93 g/cm³ and a melt flow rate (MFR₂) of 30 0.01-0.8 g/10 min.

35 6. A cable as claimed in claim 5, wherein the multimodal polyolefin has a density of 0.920-0.950 g/cm³ and a

MFR₂ of 0.2-2.0 g/10 min, and that the first polyolefin fraction has a density of 0.955-0.975 g/cm³ and a MFR₂ of 100-1000 g/10 min.

7. A cable as claimed in claim 5 or 6, wherein the 5 multimodal polyolefin has been obtained by coordination-catalysed polymerisation in at least two stages of ethylene together with an α -olefin comonomer having 3-12 carbon atoms in at least one of the stages.

8. A cable as claimed in claim 7, wherein the 10 comonomer is selected from the group consisting of 1-butene, 1-hexene, 4-methyl-1-pentene, and 1-octene.

9. A cable as claimed in claim 8, wherein the 15 polymerisation stages have been carried out as slurry polymerisation, gas-phase polymerisation, or a combination thereof.

10. A cable as claimed in claim 9, wherein the polymerisation has been carried out in a loop-reactor/gas-phase-reactor process in at least one loop reactor followed by at least one gas-phase reactor.

11. A cable as claimed in any one of the preceding 20 claims, wherein the multimodal polyolefin has an environmental stress cracking resistance (ESCR) according to ASTM D 1693 A/10% Igepal, of F10 > 8000 h, F1 > 700 h.

12. A cable as claimed in any one of the preceding 25 claims, wherein said inner layer comprises the same base polymer as the insulating layer.

13. A cable as claimed in claim 12, wherein said inner layer comprises electrically conducting particles to lower the resistivity of the layer.

14. A cable as claimed in claim 13, wherein said 30 inner layer comprises carbon black particles to lower the resistivity of the layer.

15. A cable as claimed in claim 14, wherein said inner layer comprises 0.5-20 % by weight of carbon black, 35 based on the weight of said inner layer.

16. A cable as claimed in claim 15, wherein said inner layer comprises 0.5-10 % by weight of carbon black.

17. A cable as claimed in any one of the preceding claims, wherein besides said insulating layer and said inner layer, the combined insulation/jacket includes an outer layer, that is situated on the outside of the insulating layer and that has a resistivity that is lower than that of the insulating layer so that the ratio of the resistivity of the outer layer to the resistivity of the insulating layer is less than 0.3:1.

18. A cable as claimed in claim 17, wherein said outer layer has the same composition as said inner layer.